

General Information
General

Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Latin America	
	• Europe	• North America	
Features	• Flame Retardant	• Halogen Free	• Low Shrinkage
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.19	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	20	g/10 min	ISO 1133
Molding Shrinkage - Flow	0.40 to 0.60	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2500	MPa	ISO 527-2/1
Tensile Stress (Yield)	62.0	MPa	ISO 527-2/50
Tensile Strain (Break)	> 20	%	ISO 527-2/50
Flexural Modulus ²	2600	MPa	ISO 178
Flexural Stress ²	93.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	15	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179
Notched Izod Impact Strength ³ (23°C)	13	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, Unannealed)	91.0	°C	ISO 75-2/B
Vicat Softening Temperature	99.0	°C	ISO 306/B50
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.2 mm		V-0	
1.5 mm		5VB	
2.5 mm		5VA	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	75 to 85	°C
Drying Time	3.0 to 5.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	220 to 240	°C
Middle Temperature	235 to 255	°C
Front Temperature	250 to 265	°C
Nozzle Temperature	250 to 265	°C
Processing (Melt) Temp	235 to 265	°C
Mold Temperature	50 to 80	°C
Back Pressure	0.981 to 3.92	MPa

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Lupoy® GN5001RFG

LG Chem Ltd. - Polycarbonate + ABS

Injection	Nominal Value	Unit
Screw Speed	40 to 70	rpm

Notes

¹ Typical properties: these are not to be construed as specifications.

² 2.0 mm/min

³ 6.4 mm